

Date: Tuesday, 2/26/2008 8:02:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 37633	
Estimate Number : 12593	
P.O. Number :	Part Number : D30415
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D3041REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 29686	Material :
Written By :	Due Date : 3/14/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 02 26</u>	
Comment : Est:A 01.07.11 New Issue SM/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.1094 f(s)/Unit Total : 2.1882 f(s)

Lug Extrusion

(D2423)

Batch: E 33310 C 08/02/27 (20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Check for cracks while loading into the machine

Machine as per Foto FA and Dwg D3041

Tumble and Deburr rough edges after tumbling

Identify as D3041-5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

1.1 ISSUE P/O. 5798 C 08/02/26 (20)
 Note

1.2X RECEIVE AND ATTACHMENT 08/3/10 (20)

Page 1 1.3 QCB. 08/03/11 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/03/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:13 AM

User: Kim Johnston

Process Sheet

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Drawing Name: CLAMP

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Part Number: D30415

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H

08/03/11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/07005

08/03/11

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20X)

Comment: INSPECT POWDER COAT

M-H

08/03/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 465

8/3/12

50

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/12

Job Completion



2008/3/12

(20)

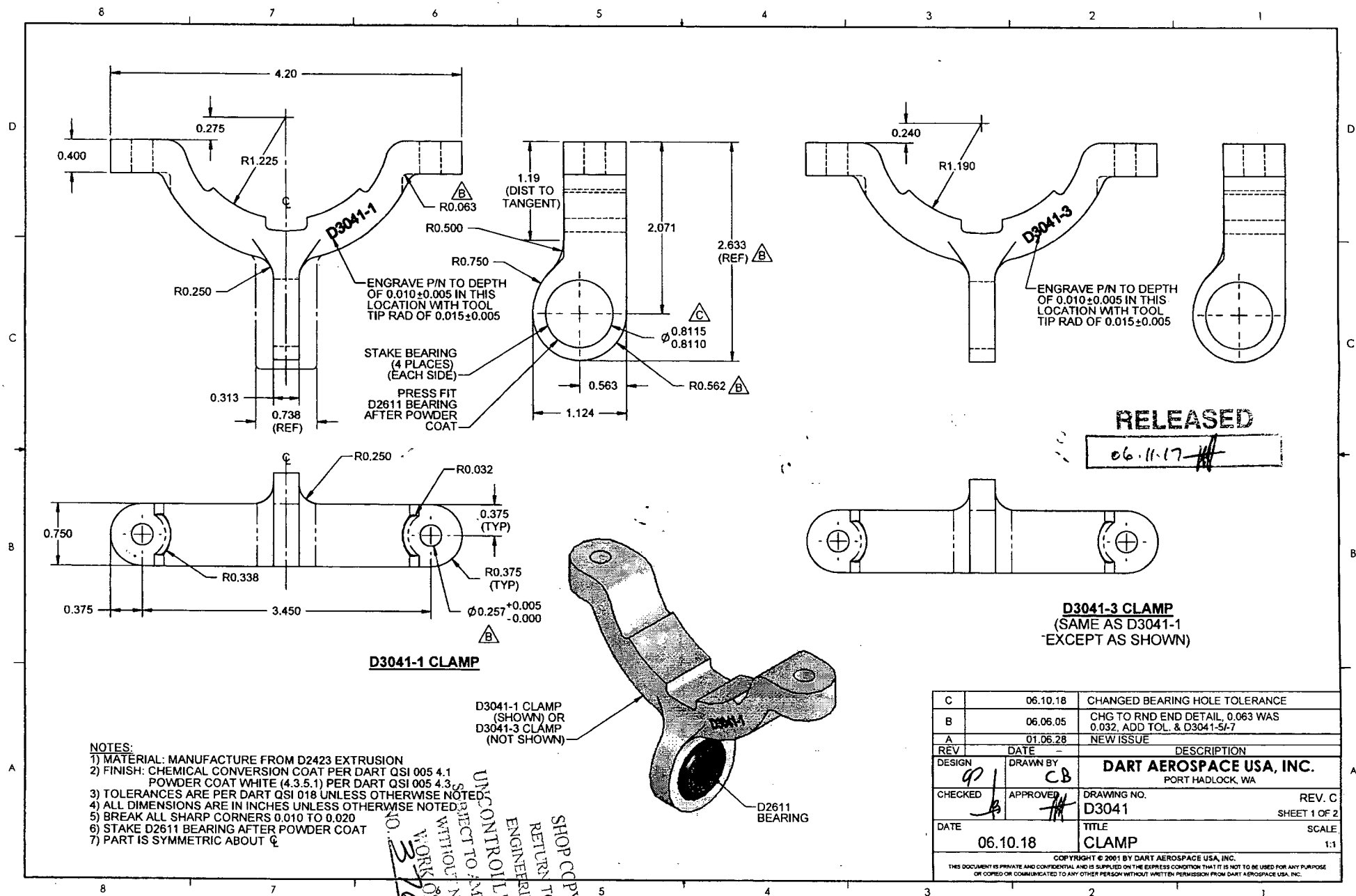
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

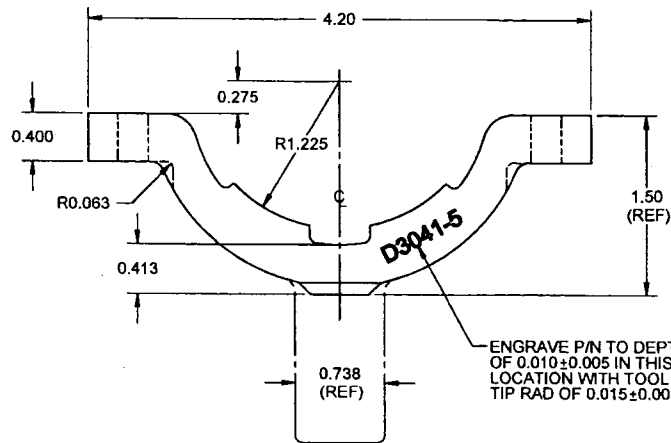
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

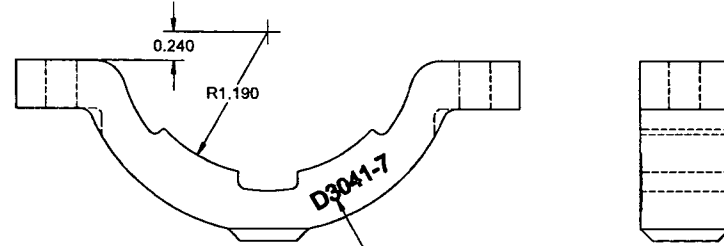


RELEASED

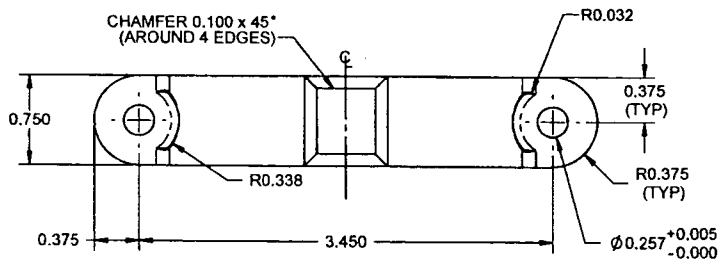
06.11.17



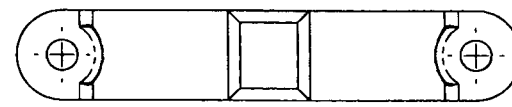
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



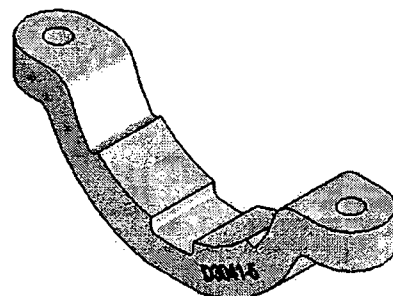
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-5 CLAMP



D3041-7 CLAMP
(SAME AS D3041-5 EXCEPT AS SHOWN)



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT C

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2633

DESIGN 97	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED A	APPROVED H	DRAWING NO. D3041	REV. C
DATE 06.10.18	TITLE CLAMP	SHEET 2 OF 2	
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.		SCALE 1:1	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3041-5	Clamp	5798
20	D3041-7	Clamp	5798

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", is written over a horizontal line.

Denise Robinson

Vankleek Hill, March 7, 2008